

Work Order ID 59607

Tuesday, June 08, 2010 3:08:46 PM



Page 1

Item ID: D4018-041

Accept



Setup Start



Revision ID:

Item Name: Short Basket Lid Assembly (350)

Stop



Start Date: 6/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: VMR

Date: CO-6-8

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4018

B

100 Weld per dwg A/R S.S. rod Batch: 4113328 0.00

Large Fab

Large Fab

Memo 0.00

1- assemble ribs , weld as per dwg D4018 using DT9607B
 2- weld hinge (3) and Mounting brackets as per dwg.D4018
 inspect before welding mesh
 3- tack weld mesh on basket as per dwg D4018
 ***make sure to place mesh correctly on lid, check with label plate before
 tacking mesh***

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Quality Control

Memo

0.00

6/10/06/10 1x

6/10/06/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Required Date: 6/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

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Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan

Accept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Packaging

Identify as per dwg & Stock Location:

6-A

0.00

Memo

w/o B59605

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MF 10-6-15

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 59607



Parent Item: D4018-041



Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 6/9/2010

Required Date: 6/14/2010

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC
per dwg revA 10.03.15 verified by:FC
DD 10.04.16 verified by:EC

IPP Rev:B as
IPP Rev:C as per dwg RevB

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 100	Unit of Each	Qty on 2.0000	Qty per Kit 1	Total 1	Qty	Date	Status
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D4035-043	Lid Rib Assembly, Aft (350 Basket)	Manufactured	No	WA	59102	100	Each	55.0000	1	1	1	10/06/10	
-----------	------------------------------------	--------------	----	----	-------	-----	------	---------	---	---	---	----------	--

D2581	Mounting Bracket	Manufactured	No	WA	59102	100	Each	55.0000	2	1	2	10/06/10	
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D4020-7	Mesh (350 Basket Short, Lid)	Manufactured	No	ST	59121	100	Each	0.0000	1	1	1	10/06/10	
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D4021-3	Data Plate	Manufactured	No	WA	46086	100	Each	6.0000	1	1	1	10/06/10	
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D4020-7	Mesh (350 Basket Short, Lid)	Manufactured	No	WA	51745	100	Each	0.0000	1	1	1	10/06/10	
---------	------------------------------	--------------	----	----	-------	-----	------	--------	---	---	---	----------	--

D4021-3	Data Plate	Manufactured	No	WA	57185	100	Each	6.0000	1	1	1	10/06/10	
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D4020-7	Mesh (350 Basket Short, Lid)	Manufactured	No	WA	58687	100	Each	0.0000	1	1	1	10/06/10	
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D4021-3	Data Plate	Manufactured	No	WA	59265	100	Each	6.0000	1	1	1	10/06/10	
---------	------------	--------------	----	----	-------	-----	------	--------	---	---	---	----------	--

D4020-7	Mesh (350 Basket Short, Lid)	Manufactured	No	WA	59610	100	Each	0.0000	1	1	1	10/06/10	
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D4021-3	Data Plate	Manufactured	No	WA	59610	100	Each	6.0000	1	1	1	10/06/10	
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D4020-7	Mesh (350 Basket Short, Lid)	Manufactured	No	WA	59610	100	Each	0.0000	1	1	1	10/06/10	
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D4021-3	Data Plate	Manufactured	No	WA	59610	100	Each	6.0000	1	1	1	10/06/10	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Picklist Print

Page 3

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Work Order ID: 59607



Parent Item: D4018-041



Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 6/9/2010

Required Date: 6/14/2010

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
D4086-232		Manufactured	No			140	Each	10.0000	1	1			



Placard, Max Load

6/9/10/15

Location Loc Qty Loc Code

ST112 10
56980 10

D2728-3



Manufactured

No

140

Each

0.0000

1

1

Dart Logo label

6/9/10/15

/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

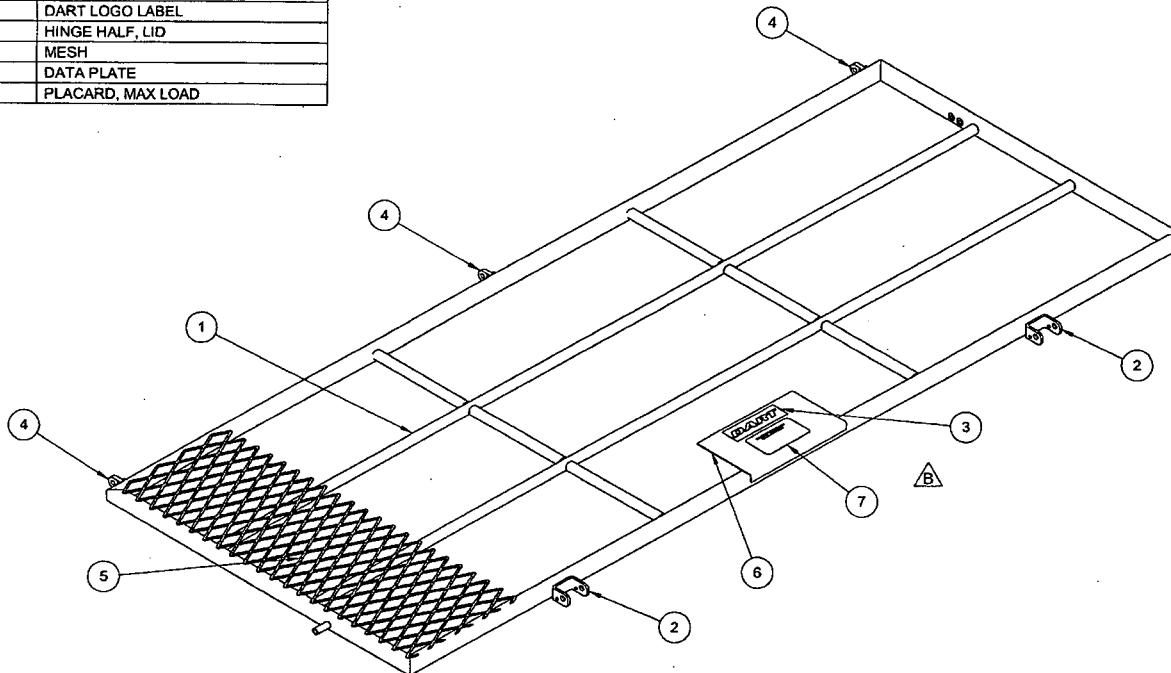
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	8	X	D4018-041
	7		SHORT BASKET LID ASSY (350)
1	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE
7	1	D4086-232	PLACARD, MAX LOAD



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

B		BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2. NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).		JPH	10.03.25
A		NEW ISSUE		JPH	10.03.04
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD			
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.		REV. B	
MFG. APPR.		D4018		SHEET 1 OF 4	
APPROVED		TITLE		SCALE	
DE APPR.		SHORT BASKET LID ASSY (350) NTS			
DATE	10.03.25	CONFIDENTIAL © 2010 BY DART AEROSPACE LTD			
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W/O:

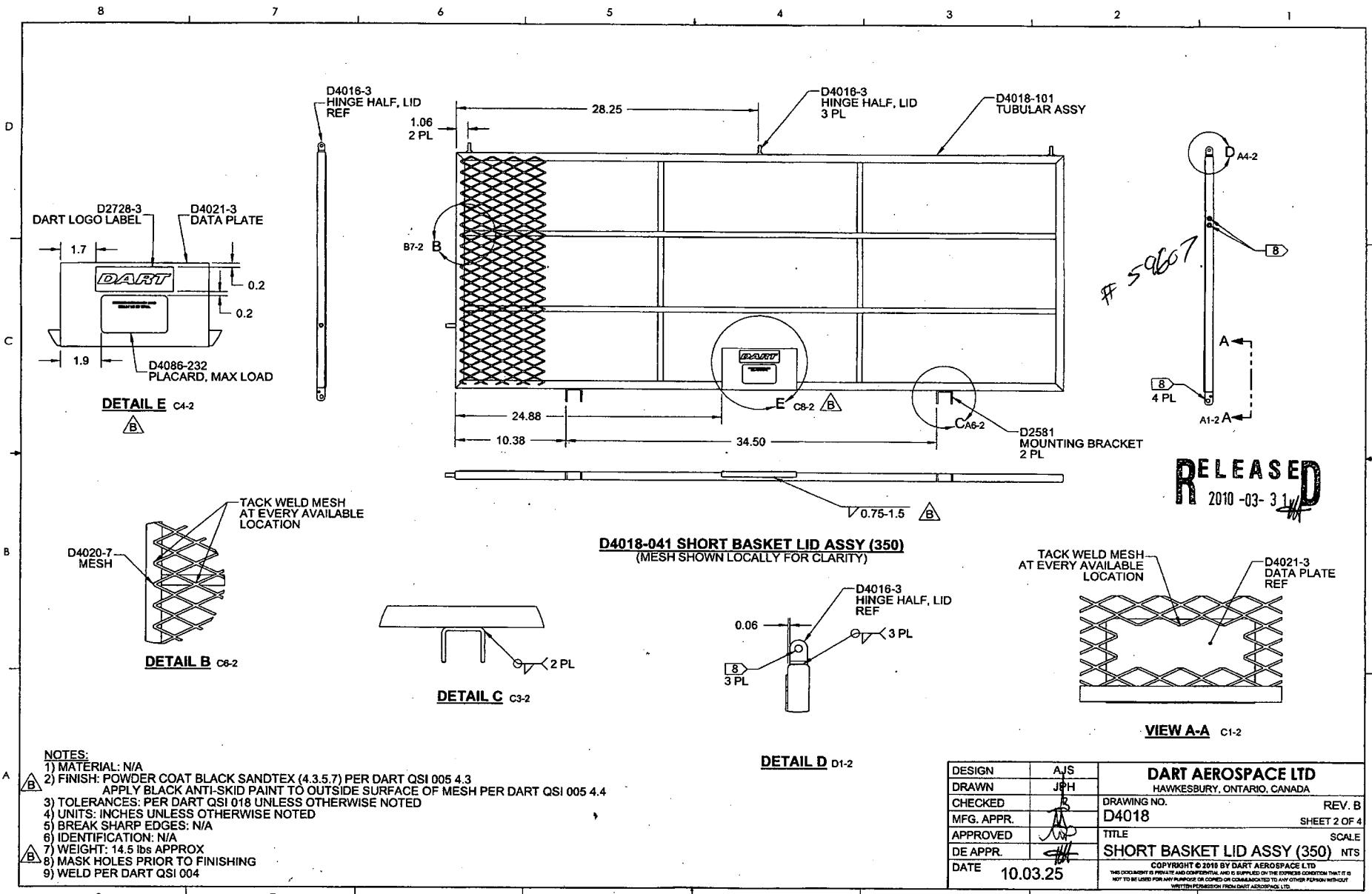
WORK ORDER CHANGES

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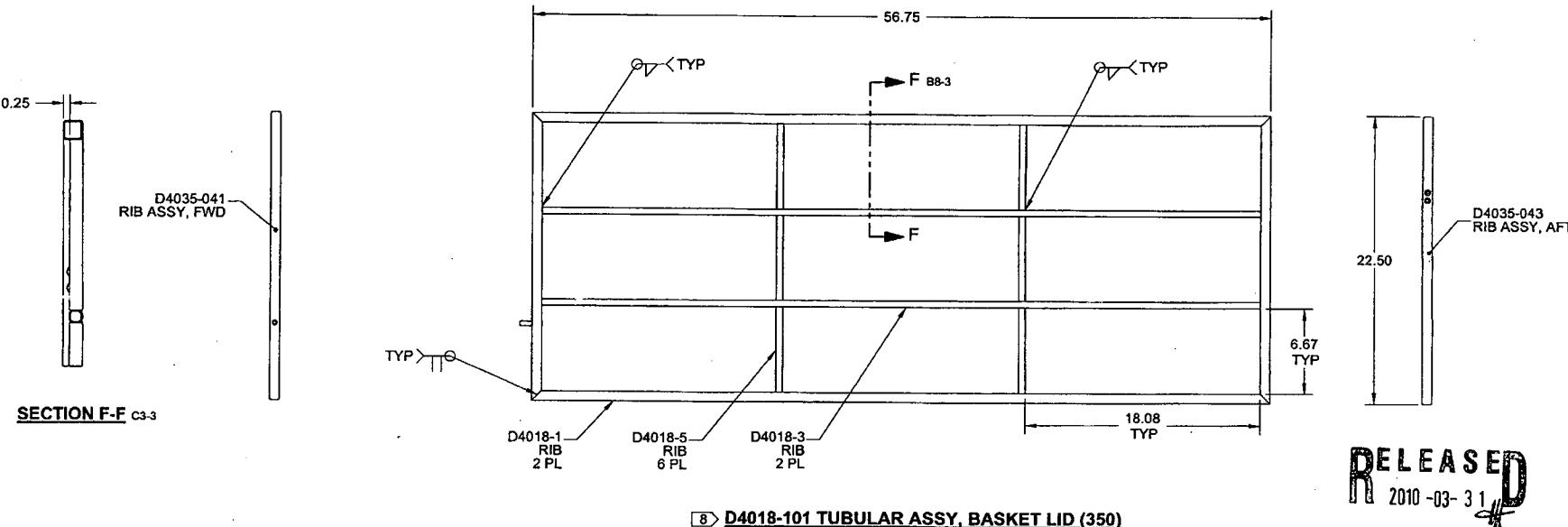
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



RELEASED
2010-03-31

#59607

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 9.06 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JRH	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D4018 SHEET 3 OF 4
APPROVED		TITLE SCALE
DE APPR.		SHORT BASKET LID ASSY (350) NTS
DATE	10.03.25	© 2010 DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. IT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

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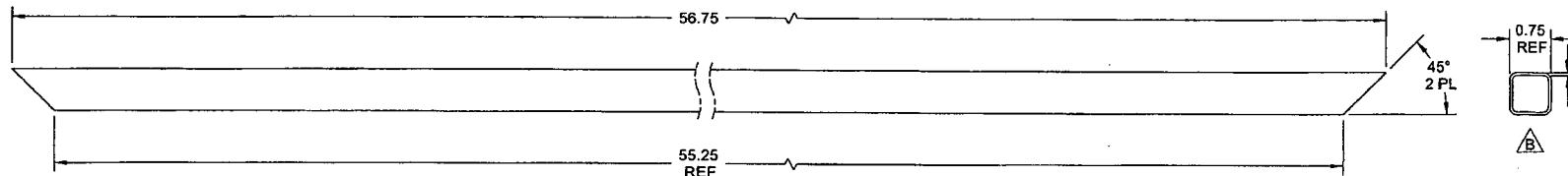
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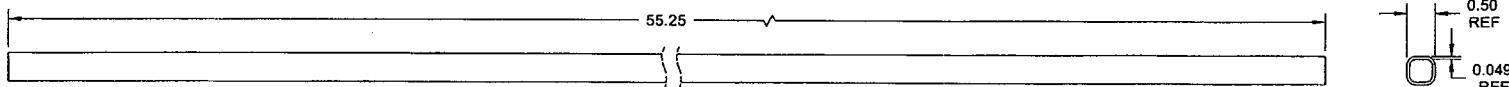
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D

**D4018-1 RIB**

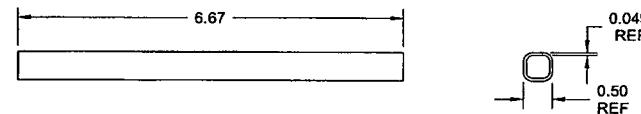
C

C

**D4018-3 RIB**

B

B

**D4018-5 RIB**

59607
RELEASED
2010-03-31

NOTES:

- 1) MATERIAL -1: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 3 & -5: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

8 7 6 5 4 3 2 1

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JRH	HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. B
MFG. APPR.		DRAWING NO. D4018 SHEET 4 OF 4
APPROVED		TITLE SCALE
DE APPR.		SHORT BASKET LID ASSY (350) NTS
DATE	10.03.25	Copyright © 2010 by DART Aerospace Ltd. This document is private and confidential and is supplied on the express condition that it is not to be used for any purpose or copied or communicated to any other person without written permission from DART Aerospace Ltd.

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